

Date: Thursday, 10/11/2007 2:55:13 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FITTING	
Job Number	35139		Part Number	D32993	
Estimate Number	11396		Drawing Number	D3299 REV B	
P.O. Number	N/A		Project Number	N/A	
This Issue	10/11/2007 S.O. No. N/A		Drawing Revision	B	
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	10/30/2007	
Previous Run	29560		Qty:	15	
Written By			Um:	Each	
Checked & Approved By					
Comment	Est: A 04.10.04 New issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6H1000	6061-T6 1" HexBar
		 Comment: Qty.: 0.1925 f(s)/Unit Total : 1.9247 f(s) 100720 07/12/12 6061-T6 1" HexBar Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex (M6061T6H1.000) Identify as D3299-3 Batch: M102605 07-12-11 07/12/12
2.0	HAAS	HAAS CNC VERTICAL MACHINING #1
		 Comment: Machine as per Folio FA452 and Dwg D3299 Deburr 07/12/12
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 07/12/12 (B)
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK 07/12/12
5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
		 Comment: Sub-Contracting OUTSIDE SERVICES 07/12/12 (XIS) 18 Issue P/O: 5290 Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:55:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FITTING
Job Number: 35139		Part Number: D32993
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached <i>do 8/10/07 (5)</i>		
7.0	QC5 	INSPECT WORK TO CURRENT STEP <i>do 8/10/07 (5)</i>
8.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: <i>ST 82</i> <i>JS 08/10/07 (5)</i>		
9.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE <i>do 8/10/08</i>		
Job Completion 		<i>mi 2007.18</i> <i>U</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35139
Description: Fitting	Part Number:	D3299-3
Inspection Dwg: D3299	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

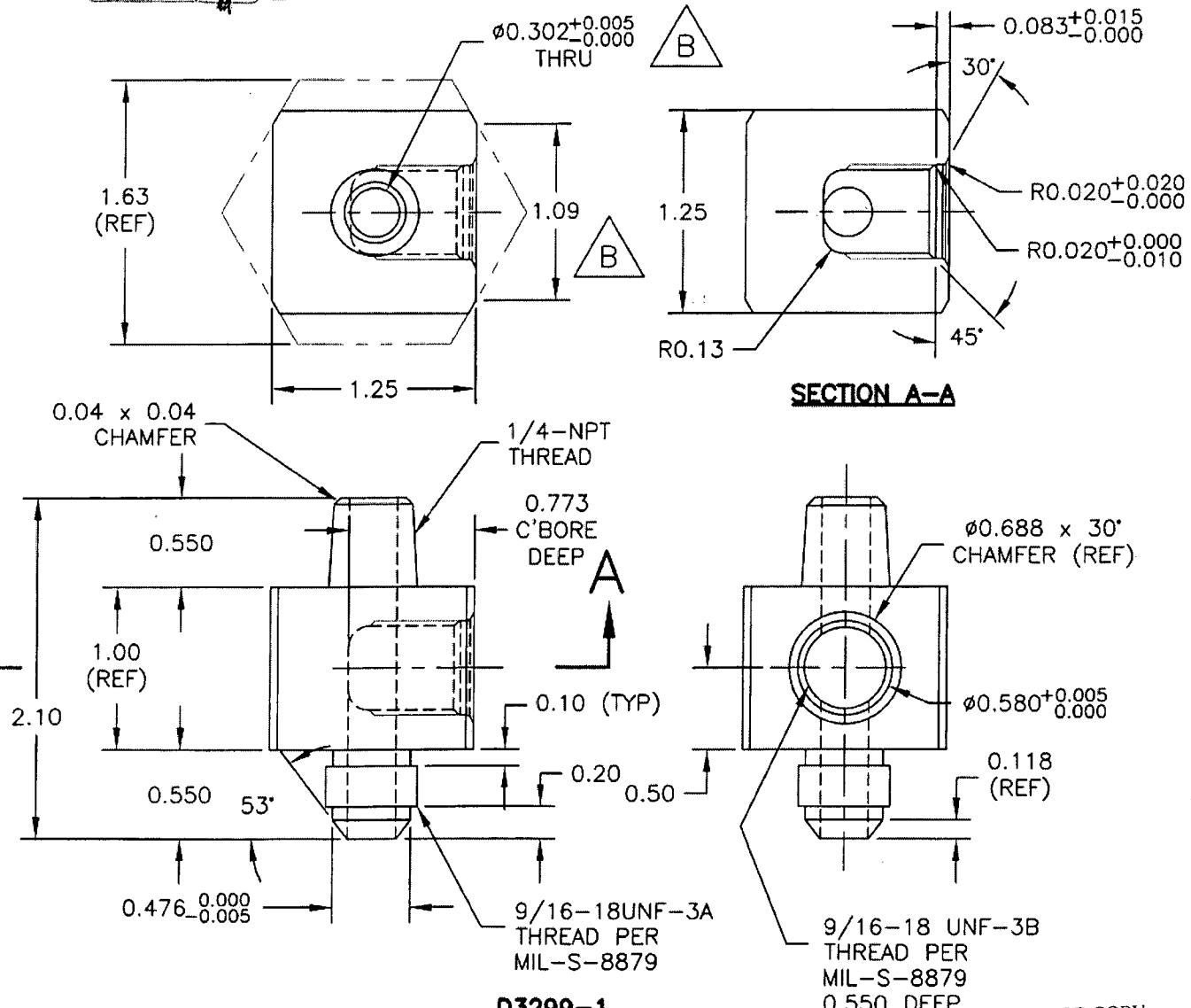
Measured by: <u>RD</u>	Audited by: <u>JL</u>	Prototype Approval: N/A
Date: <u>07/12/12</u>	Date: <u>07/12/12</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3299	SHEET 1 OF 3
DATE		TITLE	SCALE
05.04.28		FITTING	1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; Ø0.302 WAS Ø0.297	

RELEASED
05.04.28



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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SUBJECT TO AMENDMENT

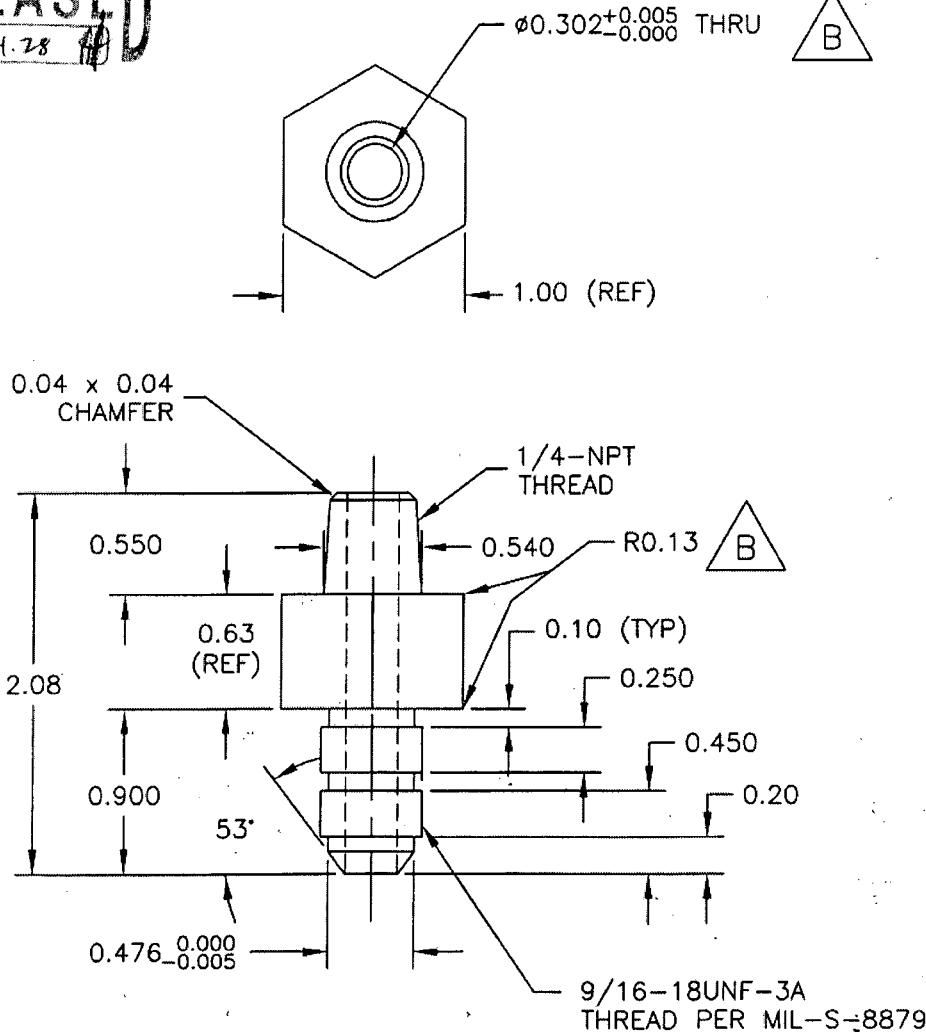
WITHOUT NOTICE

WORK ORDER

NO. 35139

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED
05.04.28**D3299-3****D3299-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

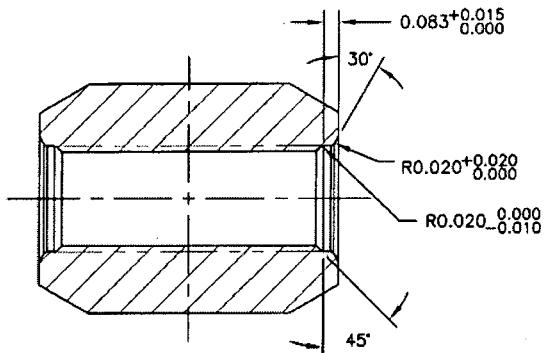
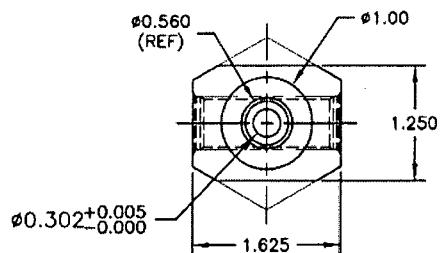
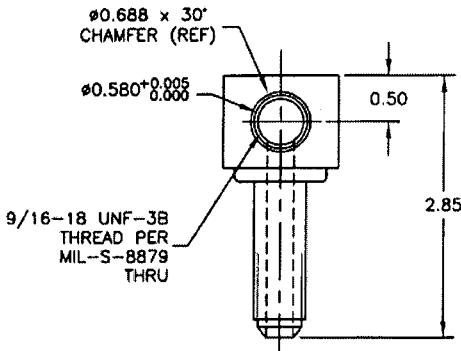
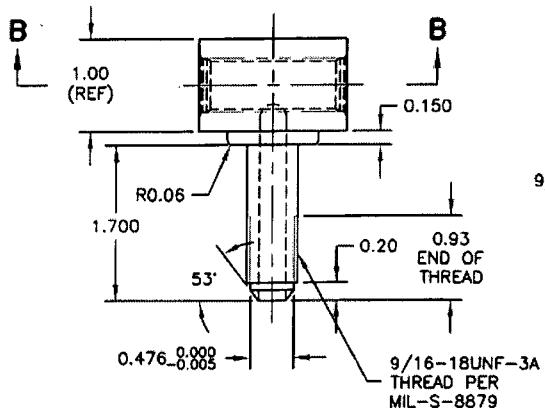
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	05.04.28	TITLE	SHEET 3 OF 3

RELEASED
05.04.28**SECTION B-B**
SCALE 1:1**D3299-5****D3299-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
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- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 / AS9100 certified
 approuvé NADCAP approved

61066

21-Dec-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET
 HAWKESBURY, ONTARIO
 K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/
NO. DE COMMANDE: 00005290

S292



ITEM	COMMANDE ORDERED	EXPE DIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	50	50	D103858B B34944	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	60	60	D103859B B34968	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	15	15	D32993 B35139	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
4	13	13	D32991 B35138	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

D. D. D. Directeur de la Qualité / Q.A. Manager

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